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DART AEROSPACE LTD	Work Order:	19984
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
Dwg: D2521 Rev. H	Qty:	600 Kits
Ref: K10015 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required	HD	03.11.24	510																																								
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately)	HD	03.11.27	56																																								
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: M14320 M14111	HD	04.01.08	10																																								
4	MV	Inspect material for defects or damage prior to machining	HD	04/01/31	6																																								
5	MV	Machine as per Folio FA222 and Dwg D2521	HD	04/01/31	6																																								
6	QC2	Inspect parts as they come off the CNC machine	HD	04/01/31	6																																								
7	MV	Deburr	HD	04/01/31	6																																								
8	MV	Form as per Dwg D2521 using bending Jig DT8328	HD	04/02/03	6																																								
9	QC8 & 5	Second inspection	HD	04-01-31	6																																								
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>8</td><td>D2182B055</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>16</td><td>D2274</td><td>Radius Block</td><td>B19599</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>B19984</td></tr><tr><td>16</td><td>D2529</td><td>Washer</td><td>B19786</td></tr><tr><td>8</td><td>D2947</td><td>Clamp</td><td>B19106- B17747</td></tr><tr><td>16</td><td>AN4-15A</td><td>Bolt</td><td>M14115</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	B19540	16	D2274	Radius Block	B19599	2	D2521	Bearpaw	B19984	16	D2529	Washer	B19786	8	D2947	Clamp	B19106- B17747	16	AN4-15A	Bolt	M14115	16	AN960JD416	Washer	M13719	16	MS21042L4	Nut (or -4)	M13276	1	Paperwork package from Step 2			HD	04-02-02	6
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1	Paperwork package from Step 2																																												
11	QC4	Inspect Kit for 100% Completeness on the W/O	HD	04-02-03	6																																								
12	PK	Identify and pack for shipping as per PPP K10015	HD	04-02-03	6																																								
13	AC	Cost / part 401.12	HD	04-02-04	6																																								
14	DC	Close W/O 387.50 Inspect Level 21	HD	04.02.05	6																																								

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	

BB 04-02-04. OK.

RELEASED
03.07.01 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 19, 2003
03:48 pm

Work Order No : 0019984
Project Name : *K10015
Project For : WK350
Work Order Type : Main
Main WO Number :
House Part Number : *K10015
Description : Bearpaw Kit
Manufactured : Yes
Amount Req'd : 5 10 6
Amount Done : 0
Start Date : 11-19-03
Est Finish Date : 12-11-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	19984
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521	Rev: H	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.000	+/-0.030	1.013	✓			
B	5.600	+/-0.030	5.670	✓			
C	11.500	+/-0.030	11.510	✓			
D	10.250	+/-0.010	10.230	✓			
E	13.250	+/-0.010	13.250	✓			
F	8.500	+/-0.010	8.500	✓			
G	22.125	+/-0.030	22.130	✓			
H	8.75	+/-0.010	8.750	✓			
I	44.500	+/-0.030	44.500	✓			
J	6.688	+/-0.030	6.685	✓			
K	5.625	+/-0.030	5.622	✓			
L	7.000	+/-0.030	7.005	✓			
M	5.000	+/-0.010	5.005	✓			
N	4.000	+/-0.030	3.985	✓			
O	6.625	+/-0.030	6.600	✓			
P	19.000	+/-0.030	19.000	✓			
Q	0.31 x 45°	+/-0.030	0.310	✓			
R	0.19 x 45°	+/-0.030	0.200	✓			
S	0.50 x 45°	+/-0.030	0.510	✓			
T	0.38 x 45°	+/-0.030	0.390	✓			
U	0.063 x 45°	+0.030/-0.010	0.065	✓			
V	Ø0.260	+0.005/-0.000	0.261	✓			
W	Ø0.93	+/-0.030	0.925	✓			
X	0.30	+0.030/-0.010	0.303	✓			
Y	0.375	+/-0.010	0.370	✓			
Z	0.750	+/-0.030	0.750	✓			
AA	0.250	+/-0.010	0.245	✓			
AB	4.000	+/-0.030	3.981	✓			
AC	6.625	+/-0.030	6.640	✓			
AD	0.950	+0.030/-0.010	0.960	✓			
AE	0.375	+/-0.010	0.385	✓			
AF	3.399	+/-0.030	3.410	✓			
AG	6.625	+/-0.030	6.630	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 09/02/24	Date: 09/01/31	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	<i>[Signature]</i>

RELEASED

04.01.15